

Date: Friday, 9/29/2006 10:44:16 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	204 SKIDTUBE "I" BEAM
<b>Job Number</b> :	28802		
<b>Estimate Number</b> :	10996		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D2597
<b>This Issue</b> :	9/29/2006	<b>S.O. No.</b> :	N/A
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2597 REV D
<b>First Issue</b> :	N/A	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	25698	<b>Drawing Revision</b> :	D
	<b>Type</b> :	<b>Material</b> :	N/A
	LANDING GEAR	<b>Due Date</b> :	10/20/2006
<b>Written By</b> :			<b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :			
<b>Comment</b> :	Est: D 98.10.15 Eliminated DEO, Changed Dwg Revision KS		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D25003100	Ext'n -I" Beam Web 4"
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Extrusion "I" Beam Web 4"

Pick;

Qty	Part Number	Description
1	D2500-3-100	Extrusion

Batch

D 25151

Pm' 06-10-21

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

Cut D2500-3 to length: 84.25"

Use Jig DT8094 to drill pilot holes.

Open to 0.625 diameter using a uni-bit.

m-b 06/10/21

(4)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

DP 6-10-23

(4)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Acid Etch and Alodine per QSI 005 4.1

m-b 6-10-24

(4)

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Pm' 06-10-30

(4)

**Comment:** INSPECT POWDER COAT/CHEMICAL CONVERSION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: 2 Date: 06/18/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/29/2006 10:44:16 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 204 SKIDTUBE "I" BEAM

Job Number: 28802

Part Number: D2597

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

*pmc 06-10-30 (4)*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



*(4)*

Comment: FINAL INSPECTION/W/O RELEASE

*06/10/31*

Job Completion



*CU 06-10-31*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

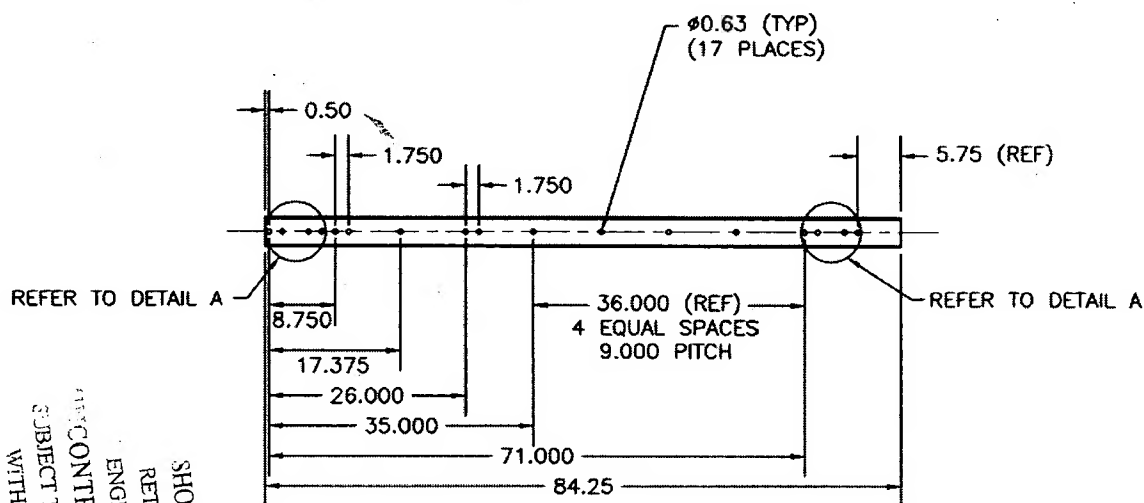
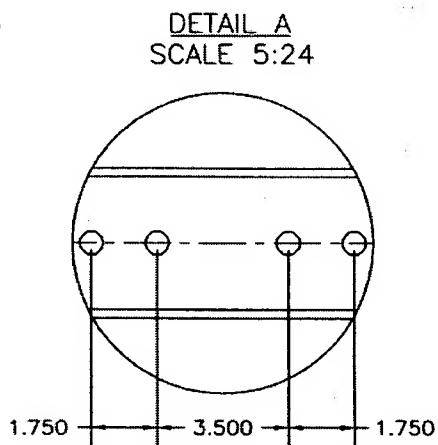
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

GA COPY  
DISTRICT

DESIGN		DRAWN BY		DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.		REV. D	
<i>[Signature]</i>	<i>[Signature]</i>	D2597		SHEET 1 OF 1	
DATE		TITLE		SCALE	
98.09.14		204 WEB		1:24	
A	96.09.16	NEW ISSUE			
B	96.10.29	5.75 WAS 0.50			
C	97.07.23	Ø0.63 WAS Ø0.56			
D	98.09.14	INCORPORATED DEO 9097			

RELEASED  
98.9.17 JS



MANUFACTURED FROM D2500-3 EXTRUSION  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 28802